

Work Order ID 59070

May 26, 2010 7:43:50 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 5/26/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3929	Rev A

100



Waterjet

Memo

0.00

B10-5-06

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B10-5-06

QC

Memo

0.00

Quality Control

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Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC8- Inspect parts - second check

0.00

S 10/06/10

(9x)

QC

Memo

0.00

Quality Control

140



Large Fab

Memo

0.00

10/06/10 (9x)

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M113328

150



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

(9) ID 10.06.04

Work Order ID 59070

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Item ID: D3929-041

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 5/26/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

**Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

0.00

S106604

(X5)

-041

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: WA

Memo

0.00

SAD 10/06-03

(9)

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/06/07 JF

MF
10-6-7

Picklist Print

Page 1

May 26, 2010 7:43:48 AM

Work Order ID: 59070



Parent Item: D3929-041



Parent Item Name: Gusset Assembly

Start Date: 5/26/10

Required Date: 5/27/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA



Purchased

No

100

sf

52.1800

0.45

2.842105

4.5



KB105-26

(9)

304/316 0.125 Sheet

LocationLoc QtyLoc Code

MAT

52.18

114488

52.18

114488

D3907-1



Manufactured

No

130

Each

48.0000

2

12



M 10/06/03

Bushing

LocationLoc QtyLoc Code

WA

48

57242

7

57937

41

(184)

DART AEROSPACE LTD	Work Order:	59070
Description: Support Gusset	Part Number:	D3929-1
4		
Inspection Dwg: D3929	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

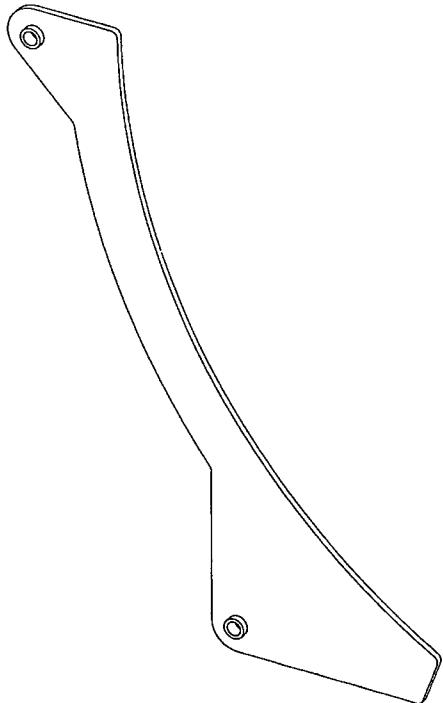
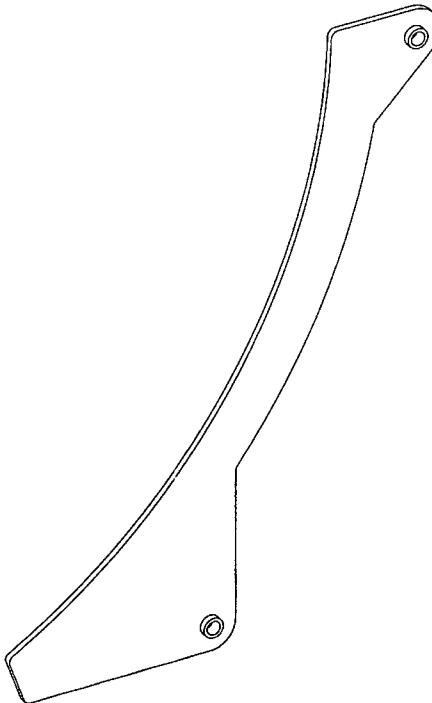
Measured by:	B
Date:	10-5-20

Audited by:	S
Date:	10/05/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.27	New Issue	P/O D3929-041/-042	KJ  

8 7 6 5 4 3 2 1

D3929-041 GUSSET ASSEMBLYD3929-042 GUSSET ASSEMBLY

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

26 59070

RELEASED
27/04/2011

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			REV. A
APPROVED			SHEET 1 OF 3
DE APPR.			TITLE
DATE	09.04.03		SCALE
			GUSSET ASSEMBLY
			NTS

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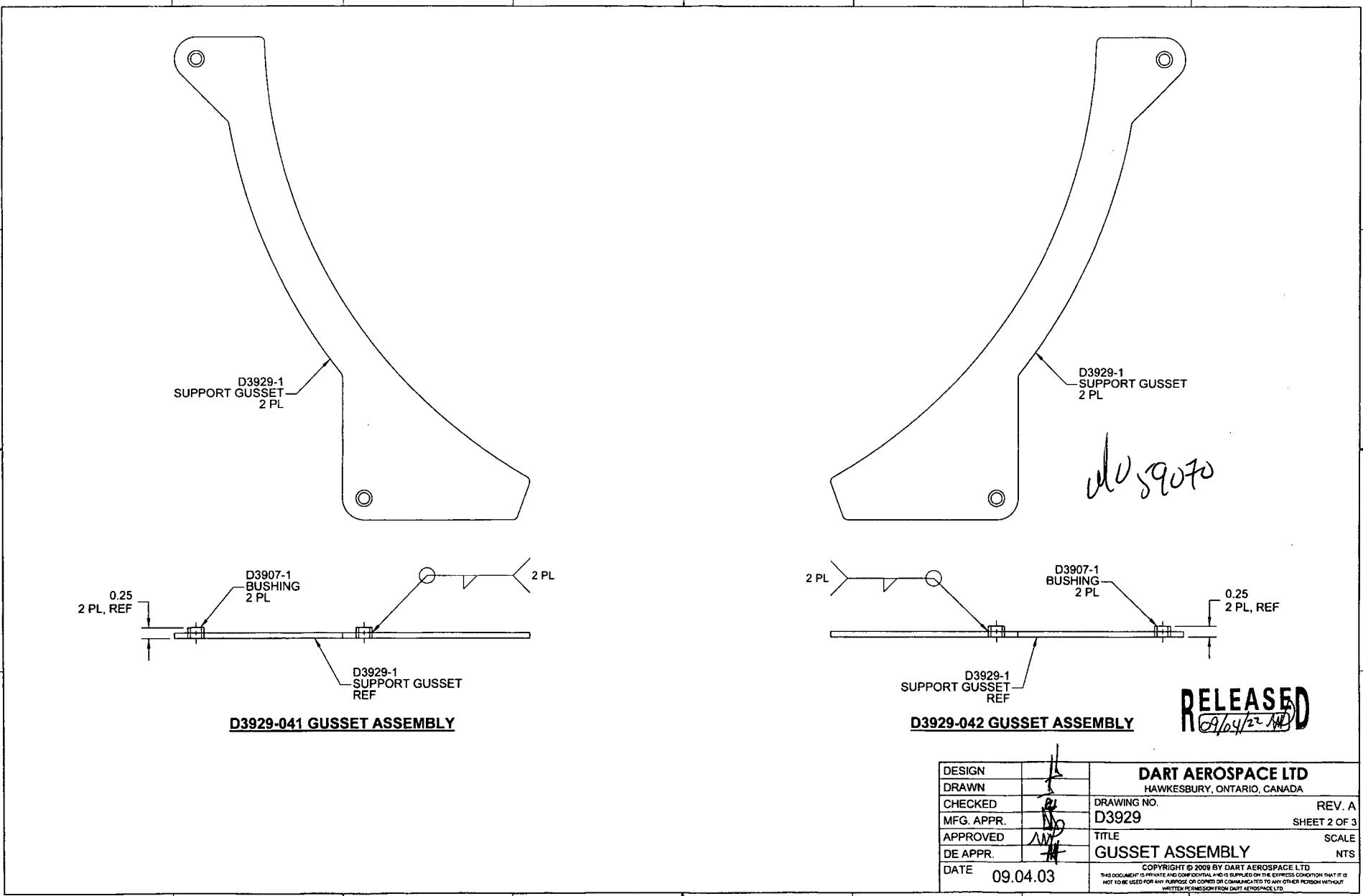
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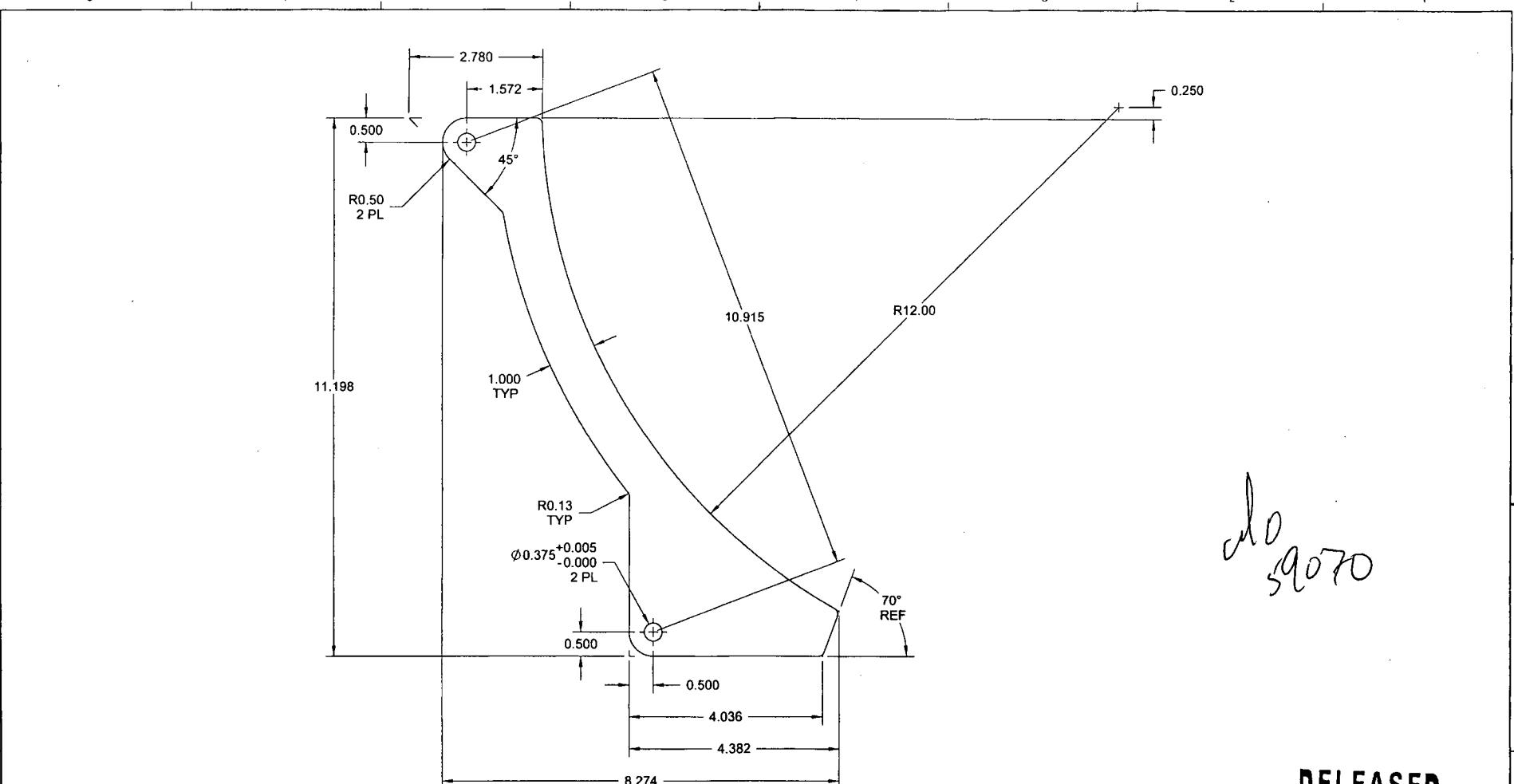
C

B

A

8 7 6 5 4 3 2 1





D3929-1 SUPPORT GUSSET

A NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	
DATE	09.04.03	NTS	

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